

**Work Order ID 55085**

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January 5, 2010 3:05:16 PM

Item ID: D4038-10

Accept



Setup Start



Revision ID:

Item Name: Aft Block, Fwd, RH

Stop



Start Date: 05/01/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4038	A-PRELIM

100 Mill Conv. 0.00



Mill Conv. Memo Conventional Milling Machine Mill as per Dwg

MW

10/01/07

(1)

X

110 QC2- Inspect parts off machine FAI/FAIB 0.00



QC Memo Quality Control

MW

10/01/07

(1)

X

120 QC8- Inspect parts - second check 0.00



QC Memo Quality Control

MW 10/01/07

1

X

**PRELIMINARY ISSUE**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55085



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Item ID: D4038-19

## Accept



## Setup Start

**Revision ID:**

**Item Name:** Aft Block, Fwd, RH

Stop

Start Date: 05/01/2010 Start Qty: 1.00



**Cust Item ID:**

Required Date: 15/01/2010 Req'd Qty: 1.00



**Customer:**

### Reference:

**Approvals:** **Process Plan:**

**Date:** \_\_\_\_\_

## Tooling

Date: \_\_\_\_\_

Run Start



QC:

**Date:** \_\_\_\_\_

SPC (Y/N):

Date: \_\_\_\_\_

## Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  <b>Memo</b>	0.00	<i>BL 10-01-7</i>			0			
150  QC Quality Control	QC3- Inspect Part Finish  <b>Memo</b>	0.00	<i>BL 10105-07</i>			0		<i>0</i>	
160  Packaging Packaging	Identify as per dwg & Stock Location: <i>DWG#5</i>  <b>Memo</b>	0.00	<i>BL 10-01-07</i>						

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 55085**

January 5, 2010 3:05:17 PM

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Item ID: D4038-10

Accept



Setup

Start



Revision ID:

Item Name: Aft Block, Fwd, RH

Stop



Start Date: 05/01/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop


**Sequence ID/  
Work Center ID**
**Operation  
Description**
**Set Up/  
Run Hours**
**Draw  
Number**
**Draw  
Rev.**
**Plan  
Code**
**Accept  
Qty**
**Reject  
Qty**
**Reject  
Number**
**Insp.  
Stamp**

170



QC21- Final Inspection - Work Order Release

0.00

QC

Quality Control

Memo

0.00

DD0329AJAN

BD 10-1-08  
(1)

POSITIVE RECALL

EFFECTIVE 01/08 AUTH U

RELEASED \_\_\_\_\_ DATE \_\_\_\_\_

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Picklist Print**

Page 1

January 5, 2010 3:05:21 PM

Work Order ID: 55085



Parent Item: D4038-10



Parent Item Name: Aft Block, Fwd, RH

Start Date: 05/01/2010

Required Date: 15/01/2010

Comments: Ipp Rev:A New Issue 09-12-14 JLM Verified By:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B1.500X02.00 0		Purchased		No			f	16.5683	0.1747			

6061-T6 Bar 1.50 x 2.00

Warehouse      Loc Qty      Loc CodeLocation

Main Warehouse

MAT	16.5683
108877	0.4736
110167	16.0947

0.1747 DTP  
10/01/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

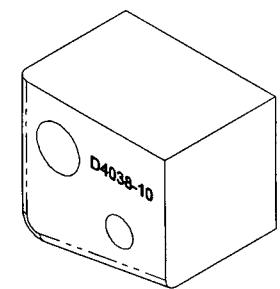
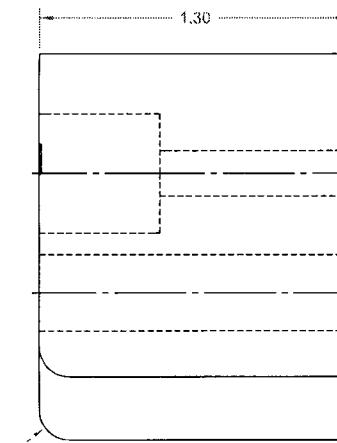
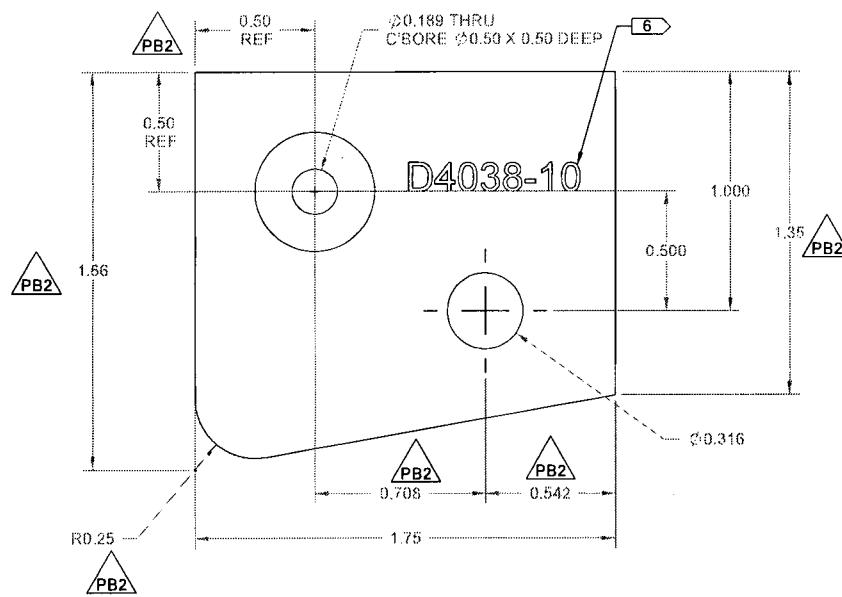
DART AEROSPACE LTD	Work Order:	55085
Description: ATT Block, Fwd, RH	Part Number:	D4038-10
Inspection Dwg: D4038 Rev: A-001LM		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## **x First Article      Prototype**

Measured by: <u>MNF</u>	Audited by: <u>One</u>	Prototype Approval:	N/A
Date: <u>10/01/07</u>	Date: <u>10/01/07</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D4038-10 BLOCK

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN TO MAX DEPTH  
OF 0.010 IN 0.12 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015
- 7) WEIGHT: 0.31 lbs

**PRELIMINARY ISSUE**

10.01.05

DESIGN DRAWN	REVIEWED 10.01.05	DART AEROSPACE LTD	
CHECKED	10.01.05	HAWKESBURY, ONTARIO, CANADA	
MFG. APPR.	10.01.05	DRAWING NO.	REV. PB2
APPROVED	10.01.05	D4038	SHEET 12 OF 14
DE APPR.	10.01.05	TITLE	SCALE
DATE	10.01.05	BRACKET	NTS

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